

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020258**Date Inspected:** 06-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11, OBG BIKE PATH (NWIT # 06873)

This QA inspector performed Magnetic Particle Testing of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A6-023-074, 075, 084, 085, 094, 095, 112, 113

BK004A3-023-054, 048

BK004A7-023-081~084, 075, 077, 078, 147, 149

BK004A4-023-002, 028, 043, 054, 069

BK004A7-023-027~030, 033~036, 170, 172

BK004A7-023-039~042, 105~108, 189, 193

BK004A7-023-051~054, 117~120, 112, 200, 202

BAY 11, OBG BIKE PATH

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This QA inspector performed green tagging for the bike path components. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004C1-024-009 GREEN TAG NO. 14337

BK005A1-003-009 GREEN TAG NO. 14338

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10, OBG BIKE PATH

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as BK004A1-028-044. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li Jun was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) number 9548.

SMAW welding of weld joint 044 located on BK004A1-028.

Welder is identified as 052930. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

TOWER FACADE SUBASSEMBLY

SMAW welding of weld joint 011, 012 & 013 located on SD1-SFSA3-39.

Welder is identified as 053829. ZPMC QC is identified as Mr. Wang Hao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

BAY 11, OBG BIKE PATH

During random in process inspection of Orthotropic Box Girder (OBG) member identified as bottom cover plate this QA observed an arc strike on Piece Mark (PCMK) identified as BK004A2-021-016. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Miss Yu Dong Ping of this issue. Miss Yu Dong Ping informed this QA that the arc strike would be corrected in a manner compliant with the contract documents.

FCAW welding of weld joint 043 located on BK004A1-020.

Welders are identified as 040704 & 053316. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2232-Tc-U4c-F.

FCAW welding of weld joint 016 located on BK004A2-021.

Welder is identified as 054460. ZPMC QC is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-L1b-F-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
